



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 175284



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/2/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/17/18	0.00	0.00	Start Up Large Fab-4		gls
110	Large Fab	1 pcs		4/17/18	0.00	0.99	Large Fab 2	DAS	gls
120	QC	1 pcs		4/17/18	0.00	0.00	QC9	24	✓
130	QC	1 pcs		4/17/18	0.00	0.00	QC5	9-89	✓
140	HandFinish	1 pcs		4/17/18	0.00	0.18	HandFinish1		SA 18-06-06
150	QC	1 pcs		4/17/18	0.00	0.00	QC7-2		CPC
180	Large Fab	1 pcs		4/17/18	0.00	0.99	Large Fab 2		Shu
190	QC	1 pcs		4/17/18	0.00	0.00	QC10		PD 18-06-12
200	QC	1 pcs		4/17/18	0.00	0.00	QC5		PD 18-06-12
210	HandFinish	1 pcs		4/17/18	0.00	0.18	HandFinish1		SA 18-06-12
220	Powdercoat	1 pcs		4/17/18	0.00	0.29	Powdercoat1		BR 18-06-12
230	HandFinish	1 pcs		4/18/18	0.00	0.18	HandFinish3		BR 18-06-12
240	QC	1 pcs		4/18/18	0.00	0.00	QC3		38
250	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging1-3		9-89
260	QC	1 pcs		4/18/18	0.00	0.00	QC4		JRB DAS
265	DC	1 pcs		4/18/18	0.00	0.00	DC		JRB 28
270	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging3-1		DAS 9-89
280	QC21-FG	1 Ea		4/18/18	0.00	0.00	QC21		21 18-06-19

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 11:45 OVEN TEMPERATURE: 300° FINISH TIME: 12:15

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

5076288x1xLH

wing walk M138851

3867

Plex 4/2/18 11:01 AM Dart.Gagnon.Michelle

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	5066631
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	5076205
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	5073664
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	79	0
	D3219-1	2	93	0
	D3272-1	1	10	0
180-Large Fab	D3065-041	1	11	0
	D3066-1	2	72	0
	MS20600-AD4W4	16	1,071	0
250-Packaging	AN3-35A	2	238	0
	AN4-13A	8	907	0
	AN5-36A	2	212	0
	D2230-3	4	154	0
	D2618	2	402	0
	D2856-400-720	2	146	0
	D3235-1	2	232	0
	D3278-041	1	10	0
	MS21042L3	2	2,768	0
	MS21042L4	8	3,942	0
	MS21042L5	2	648	0
	NAS1149D0363J	4	3,006	0
	NAS1149D0463J	16	5,782	0
	NAS1149D0563J	4	1,962	0

Part Specifications

Specifications could not be found.

180# 3723

Plex 4/2/18 11:01 AM Dart.Gagnon.Michelle



Container No: S076288



Part: D350-591-311

Job No: 175284

Serial No/Batch: S076288

Revision:

Inspector:

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Date: 05/30/18

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003867	S081183	AN3-35A	Bolt	s047337	ST348	2
003867	S081182	AN4-13A	Bolt	s067892	OVER003	8
003867	S081181	AN5-36A	Bolt	s048292	ST336	2
003867	S081180	D2230-3	Mounting Lug	s080361	ST521	4
003867	S081179	D2618	Bushing	s049859	ST008	2
003867	S081178	D2856-400-720	Abrasion Strip 4" X 7.20"	s079659	ST418	2
003867	S081177	D3235-1	Mounting Lug	s053650	ST522	2
003867	S081176	D3278-041	Support Assembly	s076688	ST522	1
003867	S081175	MS21042L3	Nut	s078167	OVER007	2
003867	S081174	MS21042L4	Nut	s078254	ST303	8
003867	S081173	MS21042L5	Nut	s041167	ST303	2
003867	S081172	NAS1149D0363J	Washer	s015269	ST263	4
003867	S081171	NAS1149D0463J	Washer	s055952	ST263	16
003867	S081170	NAS1149D0563J	Washer	s068662	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/14/18 9:25 AM dart.quirion.sonia

DS1 9400-01 5081331